

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020869**Date Inspected:** 13-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Iao (ABF)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A.DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

This QA Inspector observed the following work in progress:

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line DP3161-001 Longitudinal Stiffener to Deck Plate weld number(s) 019. Welder is identified as welder no. 050969. The welding variables recorded by ZPMC QC identified as Gui Xing Hui appeared to comply with applicable WPS(s)
WPS-B-P-2212-TC-U4b-FCM-1

FCAW welding of complete joint penetration weld joint(s) located on lift 13A East Line SEG3007A Bearing Block Stiffener to Floor Beam weld number(s) 033. Welder is identified as welder no. 055491. The welding variables recorded by ZPMC QC identified as Gui Xing Hui appeared to comply with applicable WPS(s)
WPS-B-T-2233 ESAB.

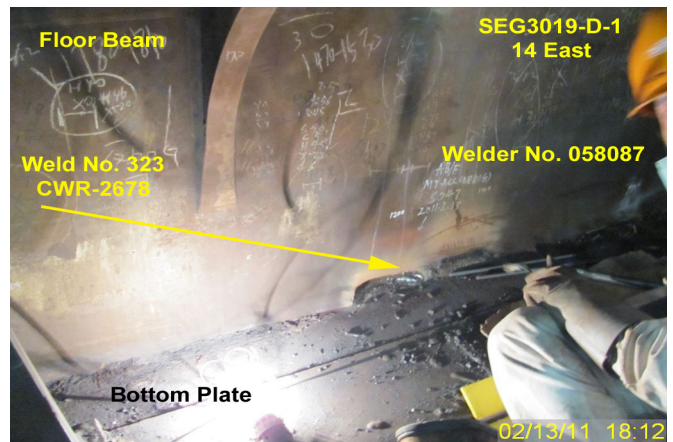
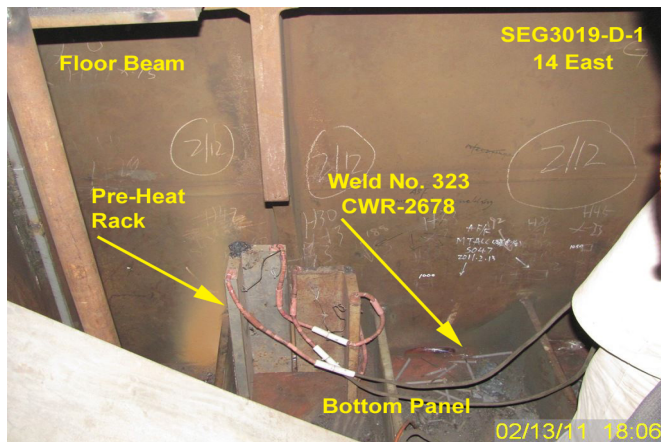
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SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG30019-D-1 Floor Beam to Bottom Plate weld number(s) 323. Welder is identified as welder no. 058087. The welding variables recorded by ZPMC QC identified as Gui Xing Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR-2678

SMAW welding of complete joint penetration weld joint(s) located on lift 14 East Line SEG30019-D-1 Floor Beam to Bottom Plate weld number(s) 323. Welder is identified as welder no. 0215553. The welding variables recorded by ZPMC QC identified as Gui Xing Hui appeared to comply with applicable WPS(s) WPS-345-SMAW-2G (2F)-FCM-Repair-1 and CWR-2678

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Jim Devy 150-002-6784, who represents the Office of Structural Materials for your project.

Inspected By: DeArmond,Robert

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer